

Work Order ID 141382

February 04, 2016 1:12:34 PM

141382

Qty 1 to ship ASAP
Qty 1 for stock

Page 1

Item ID: D212-580-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual Cargo Mirror Installation

Start Date: 2/4/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/5/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *SLA* Date: *20160204*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2161

B2

IIN-D212-580-1

B

MLJ FEB 09 2016 *(2)*

100

Document Control

0.00

DAS

DAS

100

DOCUMENT CONTROL

26

28

FEB 09 2016

DC

Memo

0.00

9-89

9-89

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D212-580-041 CHG004

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

2X *MLJ* FEB 08 2016 *51*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

Work Order ID 141382

February 04, 2016 1:12:34 PM

141382

Page 2

Item ID: D212-580-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual Cargo Mirror Installation

Start Date: 2/4/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/5/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212--580-041 LOCATION: FG010								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MWS FEB 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

February 04, 2016 1:12:41 PM

Page 1

Work Order ID: 141382

141382

Parent Item: D212-580-041

D212-580-041

Parent Item Name: Dual Cargo Mirror Installation

Start Date: 2/4/2016

Required Date: 2/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:H Removed D2013-3/-4 06-03-22 JLM
 IPP REV:I AS PER ECN10-611 10-09-07 JLM VERIFIED
 BY:DD
 10.11.22 AS PER ECN10-642 DD VERF:JLM

IPP rev:J

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3439-101		Manufactured	No			100	Each	16.0000	2	4			
D3439-101									**				DAS
Mirror Assembly 8"	DAS 28 9-89												26 9-89

Location Loc Qty Loc Code

FG 2

103697 2

ST383 14

125449 14

D2161-212		Manufactured	No			100	Each	0.0000	1				
D2161-212	DAS 28 9-89								**				DAS
Mirror Bracket, 212													26 9-89
MS20426AD3-4		Purchased	No			100	Each	2,186.000	8	16			

Location Loc Qty Loc Code

GA 1686

m131697 1686

ST312 500

m131697 500

DAS
28
9-89

FEB 08 2016

DAS
26
9-89

Hex

B 134262

SL

SL

Picklist Print

February 04, 2016 1:12:41 PM

Page 2

Work Order ID: 141382

141382

Parent Item: D212-580-041

D212-580-041

Parent Item Name: Dual Cargo Mirror Installation

Start Date: 2/4/2016

Required Date: 2/5/2016

Start Qty: 2.00

Required Qty: 2.00

D4164-041

Manufactured No

100

Each

46.0000

4

8

DAS
26
9-89

D4164-041

Nut Plate Adapter Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST090A

15

129429

15

ST096

31

118921

25

123400

6

MS27039-1-08

Purchased

No

100

Each

437.0000

4

8

DAS
26
9-89

MS27039-1-08

Screw

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

269

m128636

269

GA

2

125654

2

ST281

70

m128636

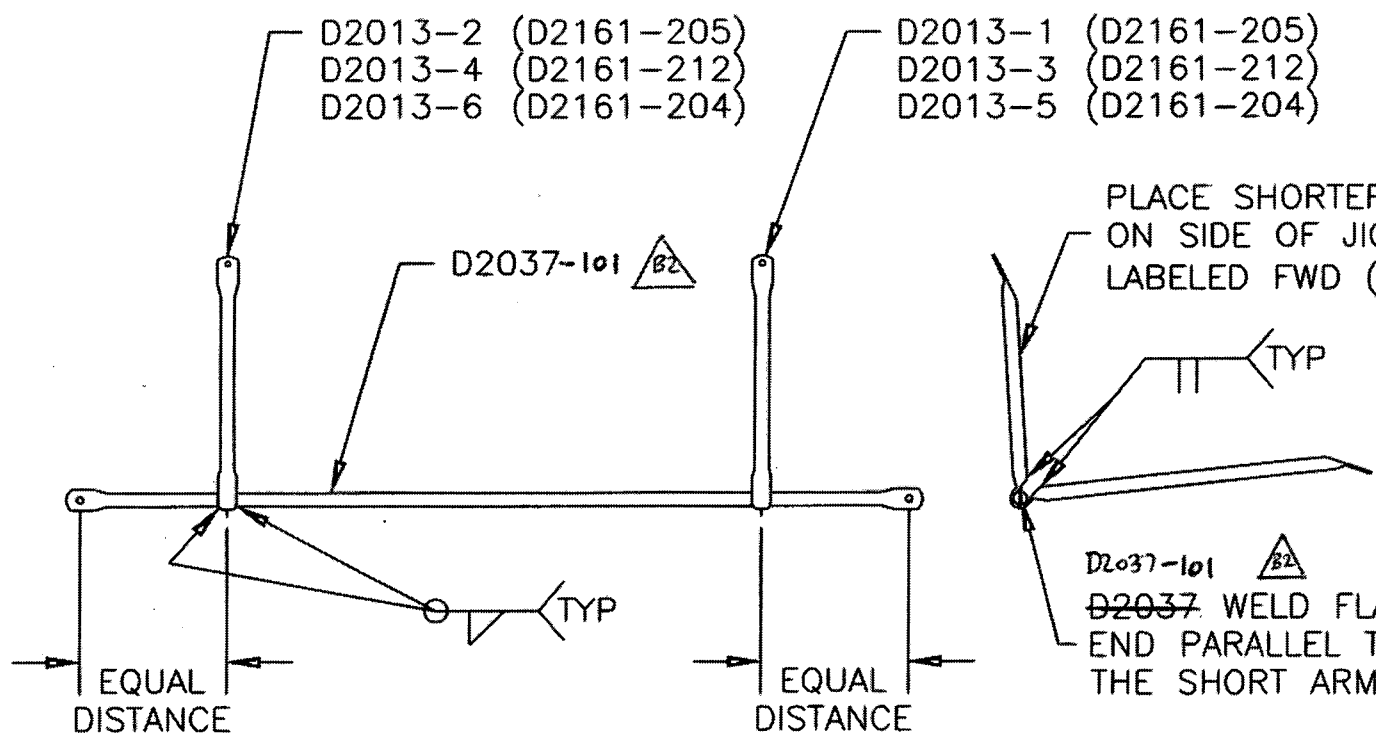
70

DAS
28
9-89

FEB 08 2016



DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RT	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
JE	RT	D2161
DATE	TITLE	SHEET 1 OF 1
99.06.07	MIRROR BRACKET	SCALE
		NTS
A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B1	02.03.25	CHANGE FINISH
B2	02.06.14	D2037-101 W



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 B1

20160204

SA
141382

RELEASED
KE 99.06.10

4.0 PARTS LIST

DAS
28
2-89

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR

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Revision: B

Date: 12.06.13